

GREEN

Date: Wednesday, 10/25/2006 11:14:01 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SADDLE FITTING, FWD (OUTBOARD/INBOARD)		
Job Number	: 29160		Part Number	: D2572		
Estimate Number	: 10531		Drawing Number	: D2572 REV E		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 10/25/2006 S.O. No. : N/A		Drawing Revision	: E		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 11/15/2006 Qty: 4 Um: Each		
Previous Run	: 28779					
Written By	: <u>JG</u> 06/10/25					
Checked & Approved By						
Comment	: Est: 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D6101005	7075-T7351 8.25X5.0X2.5
<p>Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) 7075-T7351 8.25X5.0X2.5 Make from D6101-005 billet for D2572 Ensure that grain is along 5.00" length Batch No: <u>B29160</u> x4 <u>Ep 06/10/01</u></p>		
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
<p>Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No. <u>B29160</u> Double check by: <u>JG</u></p> <p>1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges.</p> <p><u>JG/Ep 06/11/01</u> 4</p>		
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
<p>Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2571 & D2572</p> <p><u>JG/Ep 06/11/01</u> 4</p>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 06/11/16
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

4.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



SGC

06/11/01

4

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0 QC8

SECOND CHECK



Comment: SECOND CHECK

ML 06/11/03

4

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

an

06/11/10

④

7.0 POWDER COATING

POWDER COATING



M18144

Comment: POWDER COATING ~~GREEN~~

Powder Coat ~~White~~ Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

YAW 06/11/15 x 4

④

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

BB 06/11/16 ④

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ~~ST480~~

BB 06/11/16 ④

④

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

BB 06/11/16

Job Completion



CG 06/11/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order:	29160
Description: Saddle, Fwd Inboard				Part Number:	D2572
Inspection Dwg: D2572 Rev. E				Page 1 of 1	

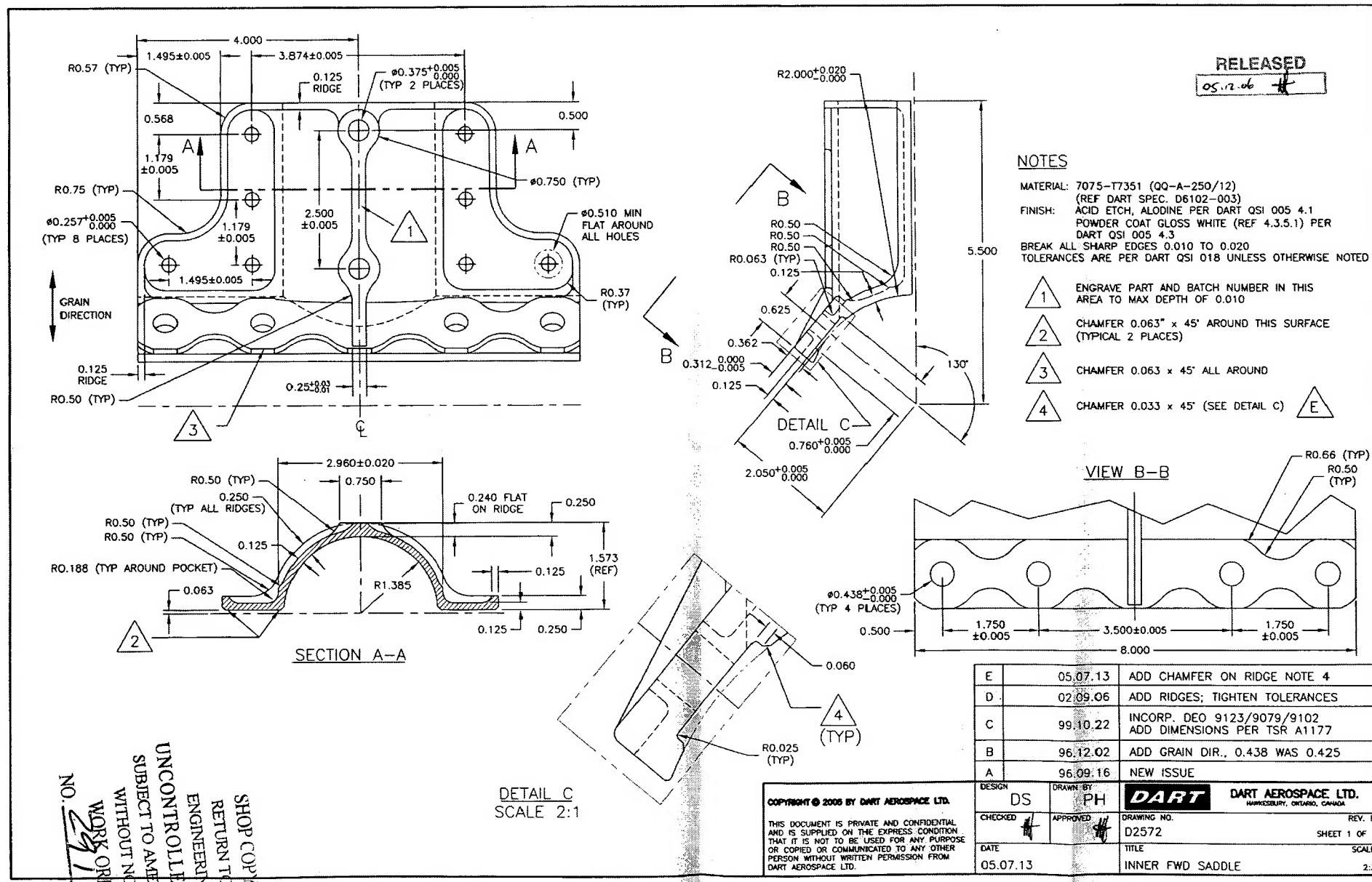
Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	0.442	0.442	0.442	0.442		
B	1.745	1.755		1.749	1.750	1.756	1.748		
C	3.495	3.505		3.500	3.499	3.498	3.497		
D	1.745	1.755		1.749	1.749	1.718	1.748		
E	7.990	8.010		8.001	8.002	8.003	8.004		
F	0.490	0.510		0.499	0.501	0.501	0.501		
G	0.257	0.262	DT8683	0.260	0.260	0.260	0.260		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.499	0.500	0.499	0.499		
J	1.174	1.184		1.176	1.177	1.177	1.177		
K	0.558	0.578		0.563	0.563	0.563	0.563		
L	1.174	1.184		1.176	1.176	1.179	1.180		
M	1.490	1.500		1.493	1.494	1.494	1.494		
N	2.495	2.505		2.498	2.499	2.498	2.498		
O	3.869	3.879		3.873	3.871	3.871	3.871		
P	0.115	0.135		0.127	0.127	0.126	0.126		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.256	0.256	0.256	0.256		
S	0.115	0.135		0.126	0.125	0.125	0.125		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.240	0.241	0.241	0.241		
W	0.115	0.135		0.125	0.124	0.124	0.125		
X	0.307	0.312		0.311	0.310	0.308	0.308		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.364	0.363	0.363	0.362		
AA	0.470	0.530		0.509	0.500	0.500	0.500		
AB	0.615	0.635		0.626	0.624	0.624	0.624		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.252	0.252	0.252	0.252		
AE	1.375	1.395		1.384	1.385	1.383	1.383		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.254	0.255	0.255	0.255		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		

Accept/Reject

Measured by:	EP / S.G	Audited by:	cmk
Date:	06/11/03	Date:	06/11/03

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	JK



NO. 291160
WORK ORDER
SUBJECT TO AMENDMENT
WITHOUT NOTICE
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY